



Dart Aerospace Ltd.
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D119-796-151
Job Sheet 174807



Part No: D119-796-151

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/17/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D119-796-151 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11 AS PER REV D JLM VERIFIED BY:DD IPP REV:E 17.12.11 REMOVE PICK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/16/18	0.00	0.00	Start Up Crosstubes-1		AS MAY 25 2018
130	Crosstubes	1 pcs		4/17/18	0.00	0.49	Crosstubes-1		AS MAY 25 2018
140	QC	1 pcs		4/17/18	0.00	0.00	QC5		38
145	DC	1 pcs		4/17/18	0.00	0.00	DC		B-80
150	Packaging	1 pcs		4/17/18	0.00	0.00	Packaging3-1	LGOSO	AS MAY 25 2018
160	QC21-FG	1 Ea		4/17/18	0.00	0.00	QC21		21 MAY 28 2018

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***
145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 005
150 - Identify and pack for shipping as per PPP D119-796-151

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-141	Fwd Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-041	Fwd Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-22	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 171243	D119-796-141 5048070	①	6	0
	D5123-3 5066028	④	318	0
	D5149-041 5051829	② 5068377	1	0
	MS21920-22 5038788	④ 5	79	0



Container No: S074460



Part: D119-796-151

Job No: 174807

Serial No/Batch: S074460

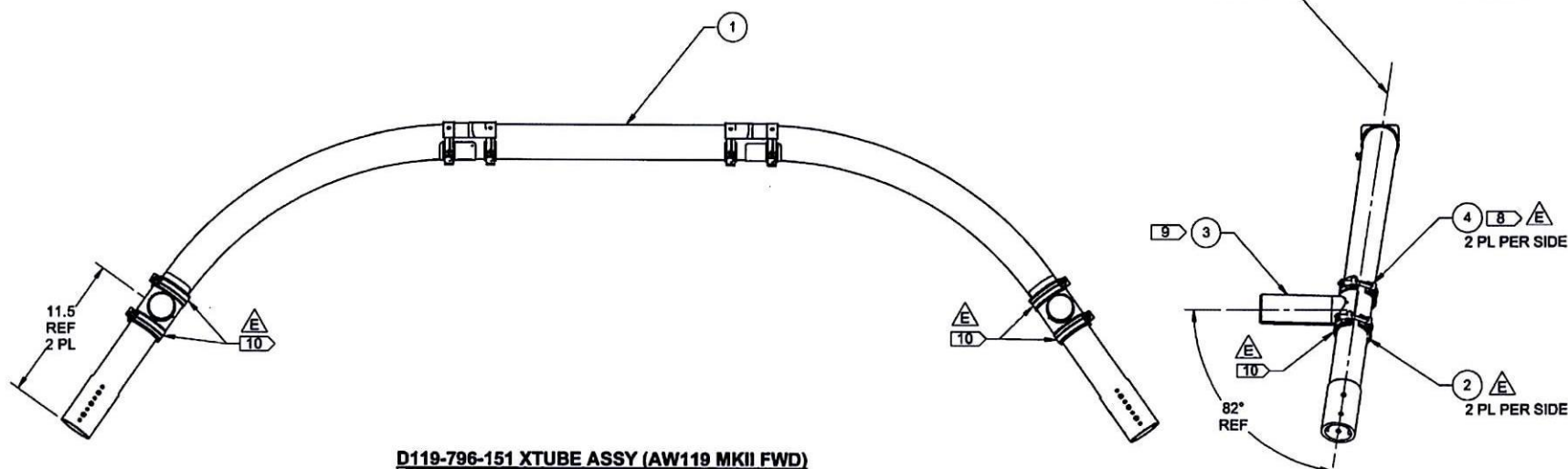
Revision: E/F

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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 174807
MAR 21 2018



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 20.01 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN. THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10 (PAR16-527) UPDATE WEIGHT DUE TO -141 CHANGE	ML	17.02.10
D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C8A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-151 TITLE XTUBE ASSY (AW119 MKII FWD) REV. E SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
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MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS		
DATE	17.02.10		

RELEASED
2017-05-04
ECN 17-538

APPROVED